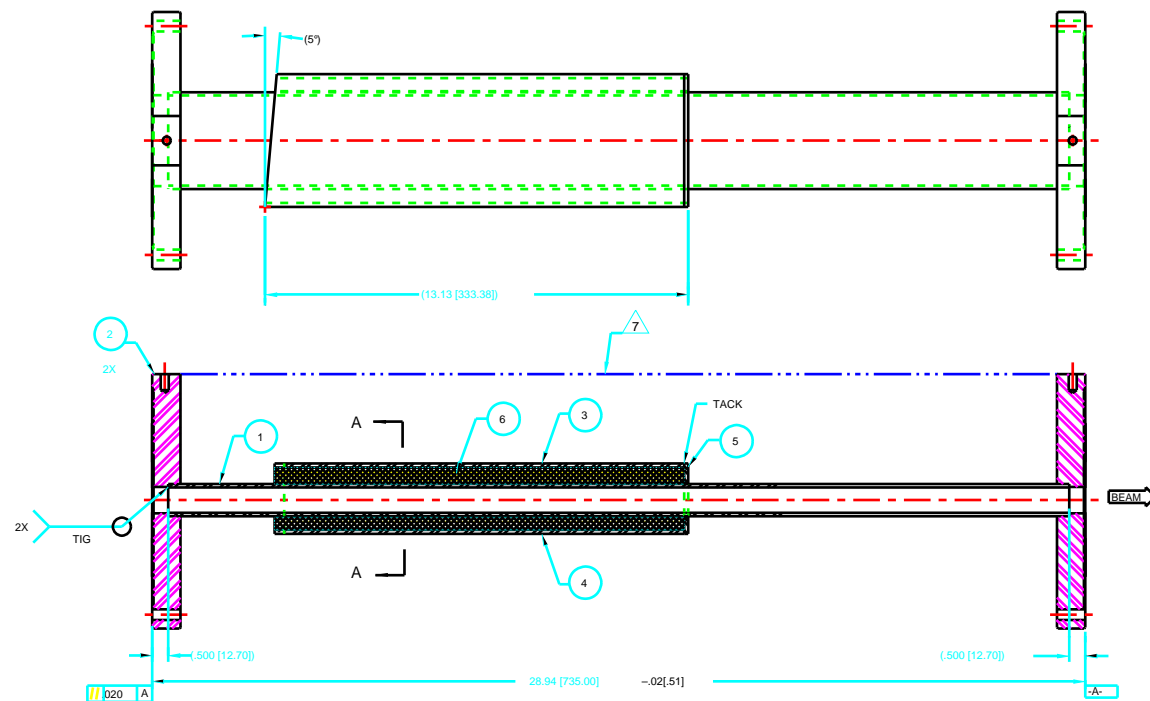


DWG. SCALE:1

1. WELD CHAMBER (ITEM #1) TO 8.0" FLANGE (ITEM #2)-ONE END ONLY.
2. SLIDE SHIELDED CAN IN PLACE -

[WELD CHANNEL R.H. (ITEM 3) TO CHANNEL L.H. (ITEM 4) AND END PLATE (ITEM 5)
INSERT LEAD COIL (ITEM 6)].

3. WELD CHAMBER (ITEM #1) TO 8.0" FLANGE (ITEM #2)-SECOND END



SECTION B-B

NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.

2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-10} STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

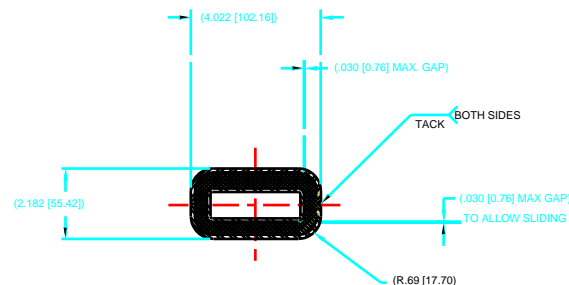
4. DIMENSIONS IN [] ARE MILLIMETERS

5. SHIELDED CAN SHALL BE TO SLIDE FREELY

6. THIS UHV PART MUST BE BAKEABLE TO 170 C.

7. BEFORE WELDING POSITION VAC CHAMBER ASSY
ON A FLAT SURFACE TO MAKE THE TWO FLATS ON THE
FLANGES COPLANAR.

8. MAX. TWIST ALLOW IN THE CHAMBER 2.5MM TOTAL



SECTION A-A

A2626500	6	P4105090602-310103-00	02 TRANSITION PIPE 1-I-D-B, LEAD COIL	LEAD GRADE "C"	1
A2627500	5	P4105090602-310106-00	02 TRANSITION PIPE 1-I-D-B, END PLATE	304SS	1
A2628200	4	P4105090602-310105-00	02 TRANSITION PIPE 1-I-D-B, CHANNEL L.H.	304SS	1
A2628400	3	P4105090602-310104-00	02 TRANSITION PIPE 1-I-D-B, CHANNEL R.H.	304SS	1
A2627200	2	P4105090602-310102-00	02 TRANSITION PIPE 1-I-D-B, END FLANGE	304SS	2
A262601	1	P4105090602-310101-00	02 TRANSITION PIPE 1-I-D-B, VAC. CHAMBER	304SS	1

LOG NO.	ITEM	QTY/UNIT QUANTITY	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	01
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PARTS LIST

[illegible]

 A2262301

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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ADVANCED RHETORIC SOURCE

SURFACE FINISHES		125	✓	ORDER #	SP LEADER	ADVANCED PHOTON SOURCE
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T.SANCHEZ	4/26/95	T.M.KUZAY	4/29/95
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U2 TRANSITION PIPE 1-ID-B	PROJECT NO.	STATION	DATE	BY

ASSEMBLY

		T. SANCHEZ	4/28/95	
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R.C.S.			MAYOR	SCALE 1/2=1	SUR	DRAWING NUMBER
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[illegible]

2 2 1

3	2	1
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01	DIM 28.94 WAS 20.00	R.C.S		
SW	CHANGE DESCRIPTION	BY	CHG'D	DATE
	REVISIONS			

[illegible]

SCALE	1/2=1	SUR	094949 121000
S-CT 1	1-1	D	P4105090602-310100-0